

Fig. 1

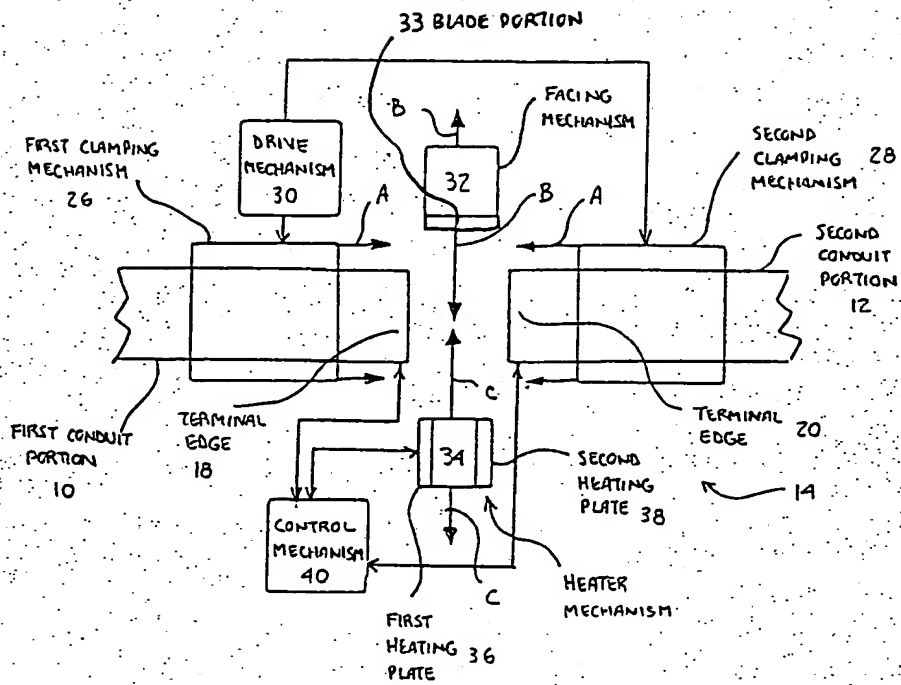


Fig. 2

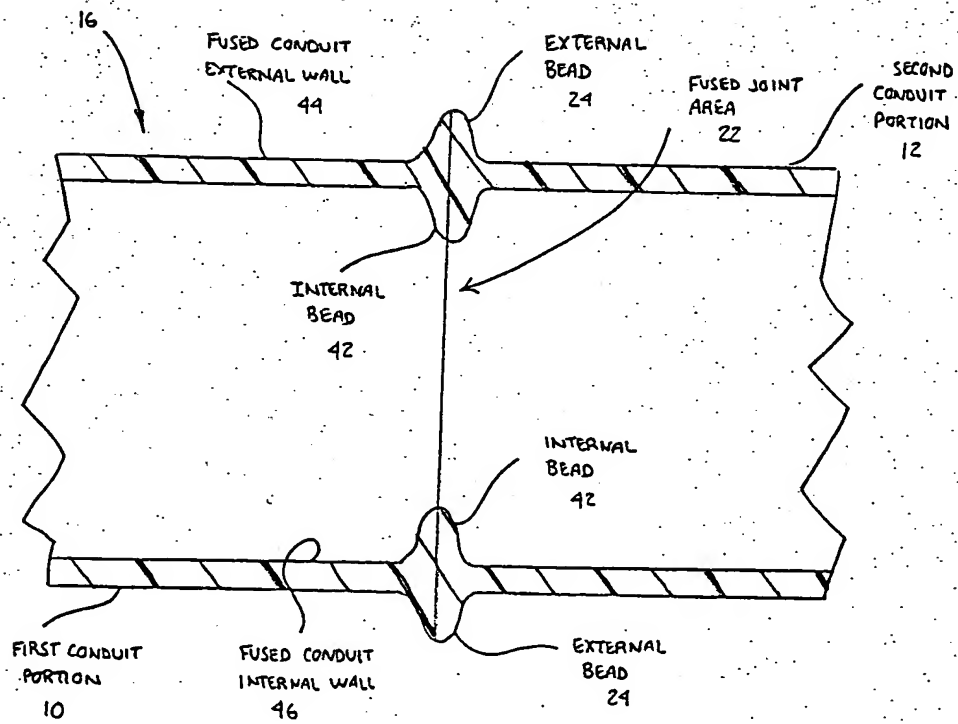


Fig. 3

PVC BUTT FUSION CHARTS
PVC AWWA PIPE

C.I.O.D. Sizes C 900 and C 905 Standards Cell class 12454 B ASTM D 1784

Pipe Dia Nominal	Outside Dia Inches	Inside Dia Inches	Surface Area sq. in.	Gauge * Pressure psi	DR Dim. Ratio	
4	4.80	4.42	2.75	385	25	
4	4.80	4.27	3.78	529	18	
4	4.80	4.11	4.83	715	14	
6	6.90	6.35	5.73	802	25	
6	6.90	6.13	7.88	1103	18	
6	6.90	5.91	9.96	1395	14	
8	9.05	8.33	9.04	1266	25	
8	9.05	8.05	12.64	1771	18	
8	9.05	7.76	16.24	2275	14	
10	11.10	10.21	14.89	2085	25	
10	11.10	9.87	20.25	2835	18	
10	11.10	9.51	25.73	3602	14	
12	13.20	12.15	20.91	2927	25	
12	13.20	11.73	28.78	4030	18	
12	13.20	11.31	36.38	5093	14	
14	15.30	14.10	27.71	3880	25	
16	17.40	16.00	36.73	5142	25	
18	19.50	17.90	47.00	6580	25	
20	21.60	19.90	55.41	7758	25	
24	25.80	23.70	81.64	11430	25	
30	32.00	29.40	148.94	20850	25	
36	38.30	35.20	178.96	25055	25	

- * Cylinder area (Cn) based on 1.00
- Interfacial Pressure 140 psi
- Plate 415° F (213° C)

FIG. 4

PVC BUTT FUSION CHARTS
PVC SERIES PIPE

* Cylinder area based on 1.00
Interfacial Pressure 140 psi
Cell Class 12454 B ASTM D 1784
Plate

SDR 41
Temp 415° F (213°C)

Pipe Dia. Nominal	Outside Dia. Inches	Inside Dia. Inches	Surface Area-Sq. In.	Gauge * Pressure psi		
4	4.50	4.278	1.53	215		
6	6.63	6.282	3.48	487		
8	8.62	8.180	5.87	823		
10	10.75	10.194	9.14	1280		
12	12.75	12.093	12.82	1795		
14	14.00	13.277	15.49	2169		
16	16.00	15.174	20.22	2832		
18	18.00	17.071	25.51	3572		
20	20.00	18.985	31.08	4350		
24	24.00	22.756	45.69	6400		

FIG. 5

SDR 32.5

Pipe Dia. Nominal	Outside Dia. Inches	Inside Dia. Inches	Surface Area Sq. In.	Gauge * Pressure psi		
3	3.50	3.271	1.22	170		
4	4.50	4.208	2.00	279		
6	6.63	6.194	4.57	640		
8	8.62	8.063	7.37	1032		
10	10.75	10.049	11.45	1604		
12	12.00	11.921	16.06	2250		
14	14.00	13.090	19.36	2710		
16	16.00	14.957	23.36	3550		
18	18.00	16.823	32.20	4508		
20	20.00	18.698	39.58	5540		
24	24.00	22.431	57.22	8010		

FIG. 6

SDR 26

Pipe Dia. Nominal	Outside Dia. Inches	Inside Dia. Inches	Surface Area Sq. In.	Gauge * Pressure psi		
3	3.50	3.215	1.50	210		
4	4.50	4.134	2.48	348		
6	6.63	6.085	5.39	755		
8	8.62	7.921	9.15	1282		
10	10.75	9.874	14.18	1987		
12	12.75	11.717	19.85	2780		
14	14.00	12.857	24.11	3375		
16	16.00	14.698	31.39	4395		
18	18.00	16.531	39.84	5580		
20	20.00	18.364	49.29	6900		
24	24.00	22.039	70.90	9927		

FIG. 7

PVC BUTT-FUSION CHARTS
PVC SERIES PIPE

* Cylinder area based on 1.00
Interfacial Pressure 140 psi
Cell Class 12454 B ASTM D 1784
Plate

SDR 21
Temp. 415° F (213°C)

Pipe Dia. Nominal	Outside Dia. Inches	Inside Dia. Inches	Surface Area Sq. In.	Gauge * Pressure psi		
3	3.50	3.146	1.85	258		
4	4.50	4.046	3.05	427		
6	6.62	5.957	6.60	924		
8	8.63	7.756	11.18	1566		
10	10.75	9.665	17.35	2430		
12	12.75	11.467	24.40	3416		
14	14.00	12.589	29.47	4125		
16	16.00	14.381	38.63	5409		
18	18.00	16.180	48.86	6840		
20	20.00	17.980	60.26	8436		
24	24.00	21.580	86.63	12128		

FIG. 8

SCH 80 INDUSTRIAL IPS

Pipe Dia. Nominal	Outside Dia Inches	Inside Dia Inches	Surface Area Sq. In.	Gauge * Pressure psi	DR	
3	3.50	2.864	3.18	445	12	
4	4.50	3.786	4.65	651	13	
6	6.63	5.709	8.57	1243	16	
8	8.62	7.565	13.48	1888	17	
10	10.75	9.493	19.98	2798	18	
12	12.75	11.294	27.50	3850	19	
14	14.00	12.412	32.94	4612	19	
16	16.00	14.224	42.16	5902	19	
18	18.00	16.014	53.05	7428	19	
20	20.00	17.814	64.92	9088	20	
24	24.00	21.418	92.10	12895	20	

FIG. 9